

Date: Thursday, 7/3/2008 3:18 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	GUIDE
Job Number :	40222		
Estimate Number :	12687		
P.O. Number :		Part Number :	D35711
This Issue :	7/3/2008 S.O. No. :	Drawing Number :	D3571 REV A
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	1 / Type : MACHINED PARTS	Drawing Revision :	A
Previous Run :	38299	Material :	
Written By :		Due Date :	7/21/2008 Qty: 21 Um: Each
Checked & Approved By :	<u>08.07.04</u>		
Comment :	Est Rev: A New Issue 07-02-01 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"
-----	--------------------	-------------------------



Comment: Qty.: 0.2531 f(s)/Unit Total : 5.3141 f(s)

6061-T6 Bar .75" X 1.5"

Batch: 1108118

H.A

08/07/05

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blank 2.90 " long

H.A

08/07/05

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA675Rev: AA & Dwg D3571 Rev: A

2-Deburr per dwg D3571

H.A/ML

08/07/05

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A/ML

08/07/05

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

H.A/ML 08/07/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/3/2008 3:31:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 40222

Part Number: D35711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(22)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: 11/1/08

7.0

POWDER COATING

POWDER COATING



Handwritten: m106442

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

Handwritten: 1:30

OVEN TEMPERATURE:

Handwritten: 320

FINISH TIME:

Handwritten: 2:00

Handwritten: BR. 12/12 08/07/10 (22)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(22)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: FZ 08/07/10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location:

Handwritten: ST 244

Handwritten: JS 08/07/10 (22)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Handwritten: 08/07/10 (22)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Handwritten: MF 08-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	40222
Description: Guide		Part Number:	D3571-1
Inspection Dwg: D3571 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

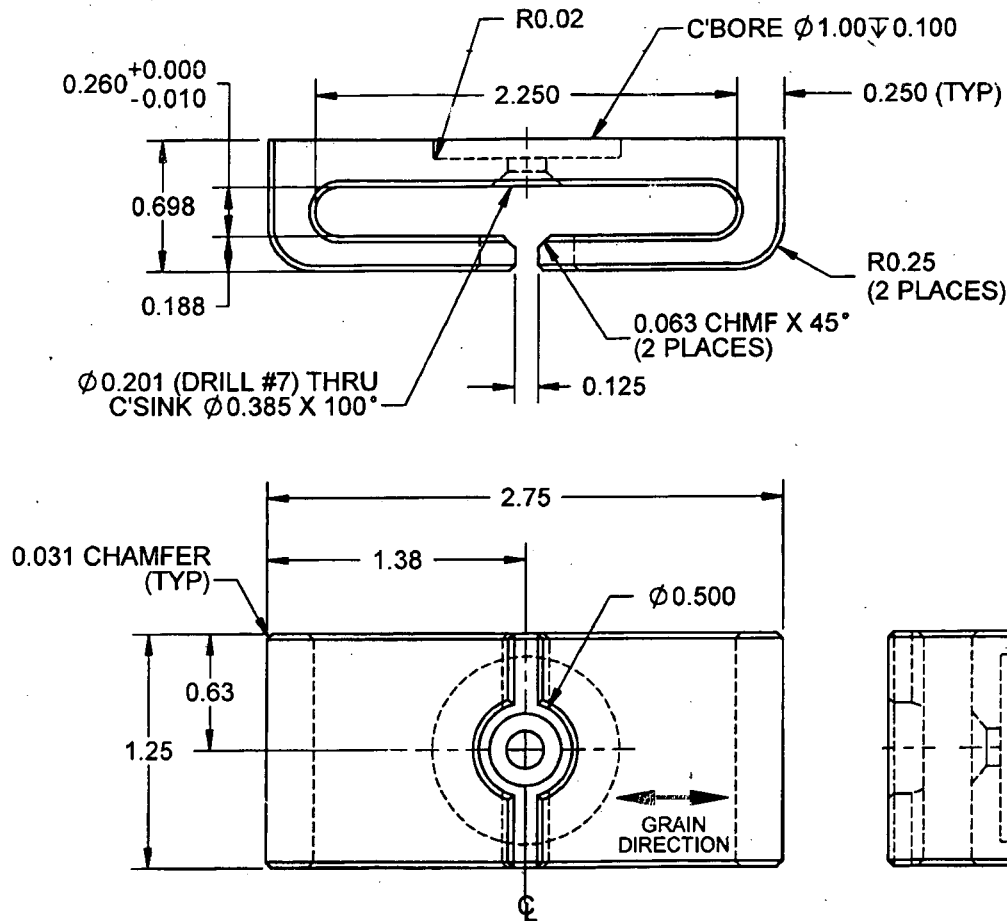
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	0.699	✓			
Ø1.00 Depth 100	+/-0.010	Ø.999 x .100	✓			
2.75	+/-0.030	2.753	✓			
1.38	+/-0.030	1.376	✓			
1.25	+/-0.030	1.249	✓			
0.63	+/-0.010	0.625	✓			
0.031 chamfer	+/-0.010	0.032	✓			
Ø0.500	+0.006/-0.001	Ø0.501	✓			
Ø0.201	+0.005/-0.001	Ø.203	✓			
R0.25	+/-0.030	R0.25	✓			
0.260	+0.000/-0.010	0.260	✓			
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	0.387 x 100°	✓			
0.125	+/-0.010	0.125	✓			
2.250	+/-0.010	2.249	✓			
0.250	+/-0.010	0.251	✓			
0.188	+/-0.010	0.188	✓			
0.063 chamfer	+/-0.010	0.070	✓			

Measured by: D.A. / amf	Audited by: DSP	Prototype Approval:	N/A
Date: 08/07/07	Date: 08/07/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	[Signature]

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 1 OF 2
DATE 07.01.29		TITLE GUIDE	SCALE 1:1
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	

RELEASED07.04.12 *[Signature]***D3571-1 GUIDE**

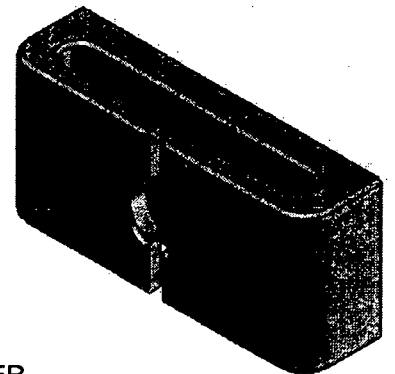
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *40222*

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT \varnothing

COPYRIGHT © 2007 BY DART AEROSPACE LTD

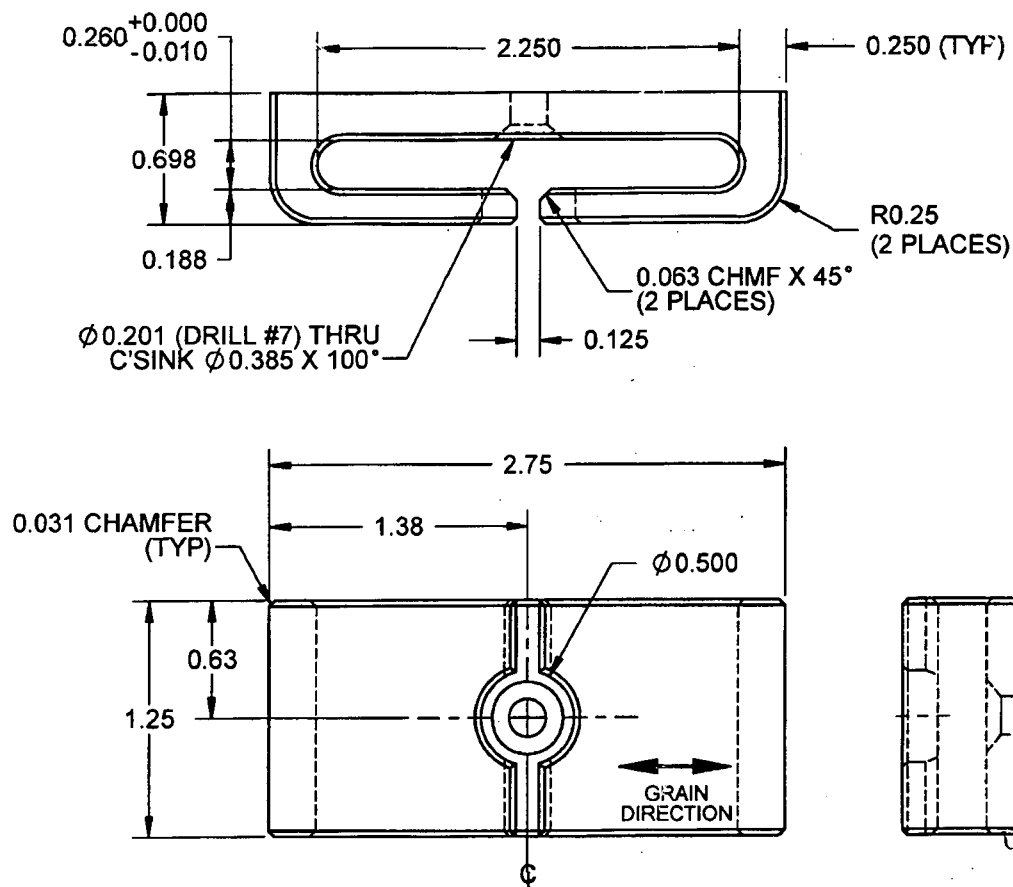
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



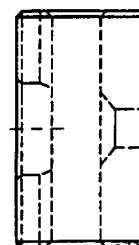


DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D3571	REV. A SHEET 2 OF 2
DATE 07.01.29		TITLE GUIDE	SCALE 1:1

RELEASED
07.04.12 *CH*



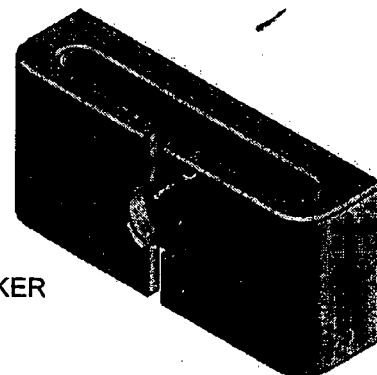
D3571-3 GUIDE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *40222*

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ



COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.